

Work Order ID 85996 - **SPLIT**

\*85996\*

Page 1

Item ID: D3183-044  
 Revision ID:  
 Item Name: Bracket Assembly  
 Start Date: 19/06/2012 Start Qty: 6.00  
 Required Date: 03/07/2012 Req'd Qty: 6.00  
 Reference:

**1**  
**120411**

Accept

\*N9000040100\*

Setup Start \*NS1\*  
 Stop \*NS2\*

Cust Item ID:  
 Customer:

Approvals: Process Plan: **MLJ**  
 QC:

Date: 12/06/19  
 Date:

Tooling:  
 SPC (Y/N):

Date:  
 Date:

Run Start \*NR1\*  
 Stop \*NR2\*

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
Draw Nbr	Revision Nbr								
D3183	Rev C1								
100		0.00							
*100*	BAND SAW								
Bandsaw	Memo	0.00							
Jeaspa Bandsaw	Cut blanks: (1.500" x 2.250") 5.500" long								
110		0.00							
*110*	HAAS CNC VERTICAL MACHINING #1								
HAAS 1	Memo	0.00							
HAAS CNC vertical machine #1	1-Machine D3183-4 as per Folio FA322 and Dwg D3183Identify as D3183-42-Deburr3-Scribe batch number								
120		0.00							
*120*	QC2- Inspect parts off machine FAI/FAIB								
QC	Memo	0.00							
Quality Control									

**PO**

**12/07/19**

**12**

**Ø**

**FK 12/07/23**

**FK 12/07/23**

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries

# Work Order ID 85996

June-19-12 12:02:03 PM

\*85996\*

Page 2

Item ID: D3183-044  
Revision ID:  
Item Name: Bracket Assembly

Accept

\*N900040100\*

Setup Start \*NS1\*

Stop \*NS2\*

Start Date: 19/06/2012 Start Qty: 6.00  
Required Date: 03/07/2012 Req'd Qty: 6.00

\*6\*

\*6\*

Cust Item ID:

Customer:

Reference:

Approvals:	Process Plan:	Date:	Tooling:	Date:	Run Start *NR1*
	QC:	Date:	SPC (Y/N):	Date:	Stop *NR2*

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
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130 QC8- Inspect parts - second check

0.00

\*130\*

QC

Memo

0.00

Quality Control

140

0.00

\*140\*

Small Fab

Small Fab

Memo

0.00

Small Fab

Assemble D3183-043 as per Dwg D3183.

150

0.00

\*150\*

QC

QC5- Inspect part completeness to step on W/O

Memo

0.00

Quality Control

20 12-7-24

1 4

1x

PS 12/07/24

DAS 16

12/07/24

4



W/O:		WORK ORDER CHANGES					
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# Work Order ID 85996

June-19-12 12:02:03 PM

\*85996\*

Page 3

Item ID: D3183-044  
Revision ID:  
Item Name: Bracket Assembly

Accept

\*N9000040100\*

Setup Start \*NS1\*  
Stop \*NS2\*

Start Date: 19/06/2012 Start Qty: 6.00  
Required Date: 03/07/2012 Req'd Qty: 6.00

\*6\*  
\*6\*

Cust Item ID:  
Customer:

Reference:

Approvals: Process Plan: Date: Tooling: Date:  
QC: Date: SPC (Y/N): Date:

Run Start \*NR1\*  
Stop \*NR2\*

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
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160

Identify as per dwg & Stock Location: \_\_\_\_\_

0.00

\*160\*

Packaging

Packaging

Memo

PPP 88024 0.00

1x

SD 12-7-24

170

QC21- Final Inspection - Work Order Release

0.00

\*170\*

QC

Quality Control

Memo

0.00

12/7/24 JG

MF 12-07-24



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**NOTE:** Date & initial all entries

# Picklist Print

June-19-12 12:02:07 PM

Page 1

Work Order ID: 85996

\*85996\*

Parent Item: D3183-044

\*D3183-044\*

Parent Item Name: Bracket Assembly

Start Date: 19/06/2012

Required Date: 03/07/2012

Start Qty: 6.00

Required Qty: 6.00

## Comments:

IPP Rev:Pick:A04.02.18New issueKJ/DS

IPP Rev:B Changed Mat Size 08-06-26 JLM Verified By:EC

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
---------------------------------	------------------------	---------------	-------------	---------------------	------------------	-----------------	--------------------	----------------	-------------	--------------	---------------	----------------	--------

D3183-045

Manufactured No

100

Each

26.0000

2

12

\*D3183-045\*

Bearing Assembly

\*\*

*GP 12/07/12*

### Location

### Loc Qty

### Loc Code

ST236

26

77830

1

79697

4

80903

21

D3121-21

Manufactured No

140

Each

95.0000

2

12

\*D3121-21\*

Bolt

\*\*

*GP 12/07/12*

### Location

### Loc Qty

### Loc Code

ST235

95

66969

1

79732

4

83364

11

85332

19

85660

60

M174B1.500X02.250

Purchased

No

140

f

22.8479

0.4583

2.894526

\*M174B1 500X02 250\*

17-4 SS Bar 1.50 X2.250

\*\*

### Location

### Loc Qty

### Loc Code

MAT031

22.8479

108309

1.08

113568

11.8333

115806

3.0846

121026

6.85

*PO 12/07/12*

*6.85*



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**NOTE:** Date & initial all entries



<b>DART AEROSPACE LTD</b>		<b>Work Order:</b>	85996
<b>Description:</b> Bracket		<b>Part Number:</b>	D3183-4
<b>Inspection Dwg:</b> D3183	<b>Rev:</b> C1	<b>Page 1 of 1</b>	

### FIRST ARTICLE INSPECTION CHECKLIST

Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
R0.190	+/-0.030	.190	✓		<del>FK-04</del>	Vern. radl gauge
R0.063	+/-0.010	.063	✓		radl gauge	"
0.182	+/-0.010	.190	✓		FK-04	Vern.
0.070	+/-0.010	.070	✓		"	"
0.100	+/-0.010	.099	✓		"	"
Ø0.201 x 0.100	+/-0.010	Ø.200 x .106	✓		"	"
0.182	+/-0.010	.189	✓		"	"
5.32	+/-0.030	5.333	✓		31006	Height gauge.
5.036	+/-0.010	5.040	✓		"	"
2.120	+/-0.010	2.120	✓		FK-04	Vern.
1.290	+/-0.010	1.290	✓		"	"
0.365	+/-0.010	.369	✓		"	"
0.218	+/-0.010	.218	✓		"	"
1.030	+/-0.010	1.032	✓		"	"
1.90	+/-0.030	1.90	✓		"	"
1.012	+/-0.010	1.008	✓		"	"
Ø0.201 x 0.100	+/-0.010	.200 x .106	✓		"	"
0.786	+/-0.010	.781	✓		"	"
Ø0.392	+0.002/-0.000	.3929	✓		FK-01	Mic.
R0.19	+/-0.030	.190	✓		radl gauge	"
3.954	+/-0.010	3.958	✓		31006	Height gauge.
0.162	+/-0.010	.161	✓		FK-04	Vern.
R0.19	+/-0.030	.190	✓		radl gauge	"
R0.25	+/-0.030	.25	✓		"	"
4.26	+/-0.030	4.273	✓		FK-04	Vern.
2.800	+/-0.030	2.800	✓		FK-04	Vern.
Calculated dimension					FK-04	Depth gauge
0.162	+/-0.010	.163	✓		FK-04	Vern.
0.615	+/-0.010	.618	✓		"	"
0.435	+/-0.010	.431	✓		"	"
0.200	+/-0.010	.200	✓		"	"
0.381	+/-0.010	.381	✓		"	"
0.032	+/-0.010	.031	✓		FK-06	Depth gauge.

<b>Measured by:</b> FK	<b>Audited by:</b> [Signature]	<b>Preliminary Approval:</b>	N/A
<b>Date:</b> 12/07/23	<b>Date:</b> 12.7.24	<b>Date:</b>	N/A

Rev	Date	Change	Revised by	Approved
A	03.11.12	New Issue P/O D3183-044	KJ/RF	
B	04.03.15	Changes as per revision C	KJ/JLM/RF	
C	04.06.15	Dimension 2.800 was 2.080; removed 1.155, 0.36 dimensions	KJ/JLM	
D	06.03.09	Dwg Rev update	KJ/JLM	
E	08.01.16	Dimensions revised	KJ/EC/DD	
F	10.09.23	Dimensions revised	KJ	[Signature]

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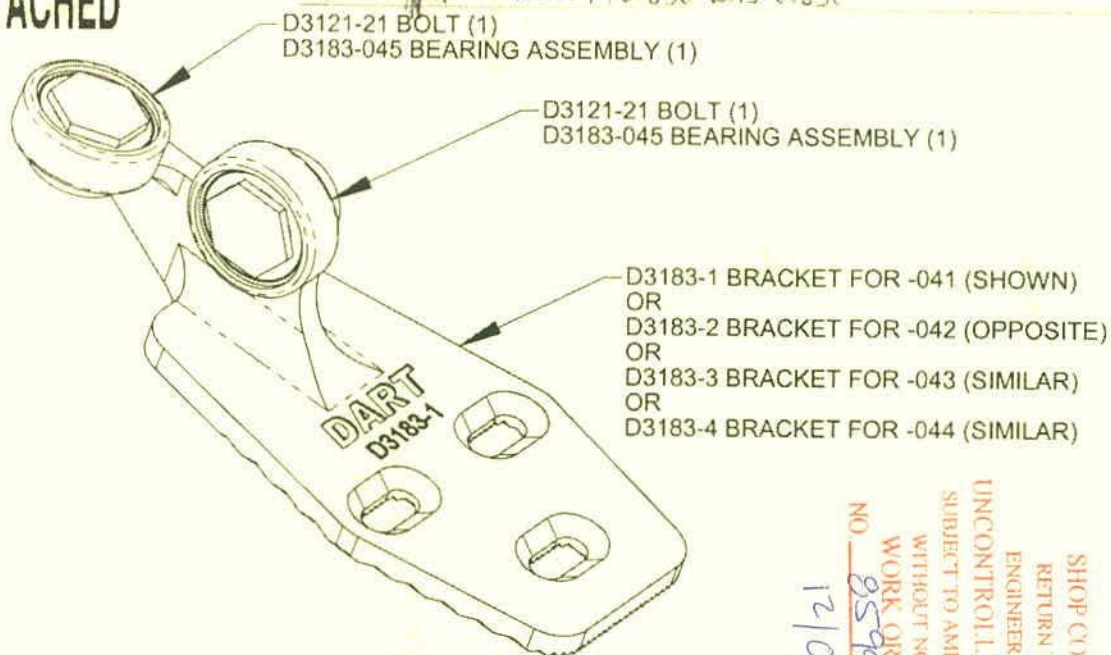
NOTE: Date & initial all entries



**DART**

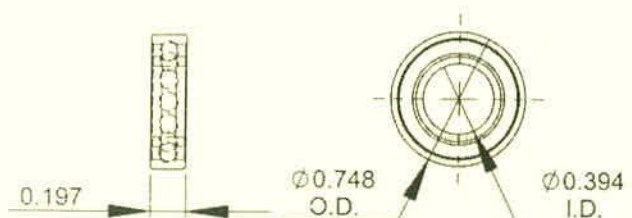
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CHECKED #	APPROVED #	DRAWING NO. <b>D3183</b>	REV. C SHEET 1 OF 4
DATE <b>04.02.17</b>		TITLE <b>BRACKET ASSEMBLY</b>	SCALE 1:1
A	03.01.24	NEW ISSUE	
B	03.06.17	REMOVE BEARING; 1.012 WS 0.882	
C	04.02.17	ADD -045/-9; 0.182 WAS 0.431	
C1	04.11.07	0.830 WAS 0.850	

RELEASED  
04.03.17  
DEO ATTACHED



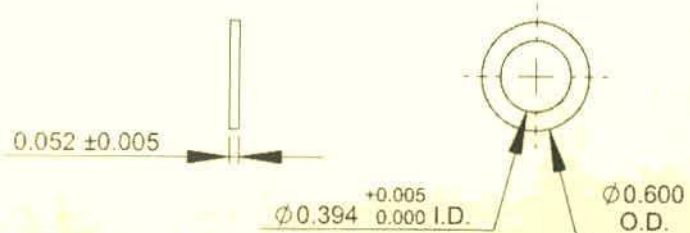
**D3183-041 BRACKET ASSEMBLY (SHOWN)**  
**D3183-042 BRACKET ASSEMBLY (OPPOSITE)**  
**D3183-043 BRACKET ASSEMBLY (SIMILAR)**  
**D3183-044 BRACKET ASSEMBLY (SIMILAR)**

SHOP COPY  
RETURN TO  
ENGINEERING  
UNCONTROLLED COPY  
SUBJECT TO AMENDMENT  
WITHOUT NOTICE  
WORK ORDER  
NO. 85996415  
12/06/19



**D3183-5 BEARING:**  
**SPECIFICATION CONTROL DRAWING**

- 1) SINGLE ROW, DEEP GROOVE, CONRAD TYPE, SHIELDED
- 2) POSSIBLE SUPPLIER: NSK P/N 6800ZZ
- 3) ALL DIMENSIONS ARE IN INCHES



**D3183-7 WASHER**

- 1) MATERIAL: AISI 303 ROUND BAR (M303R) ANNEALED
- 2) BREAK ALL SHARP EDGES 0.005 TO 0.010
- 3) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) ALL DIMENSIONS ARE IN INCHES

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W/O:		WORK ORDER CHANGES						
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector	

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

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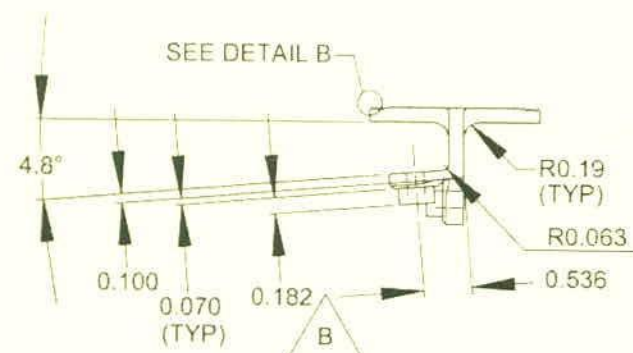
05996

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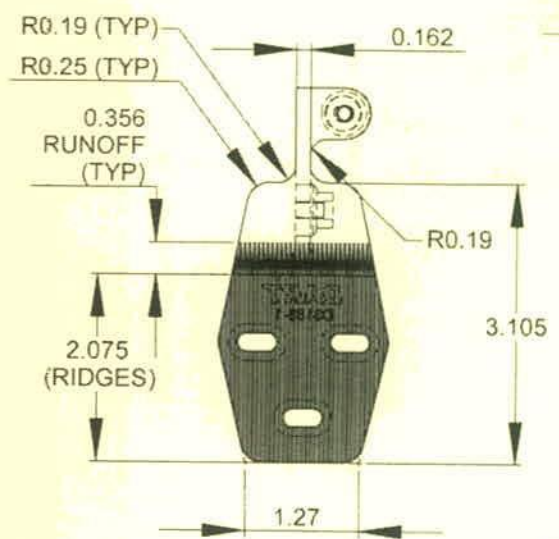
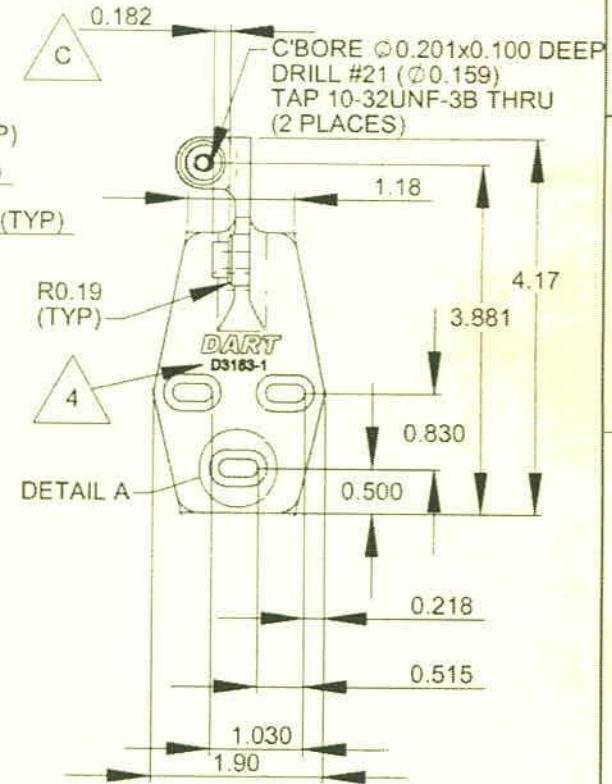
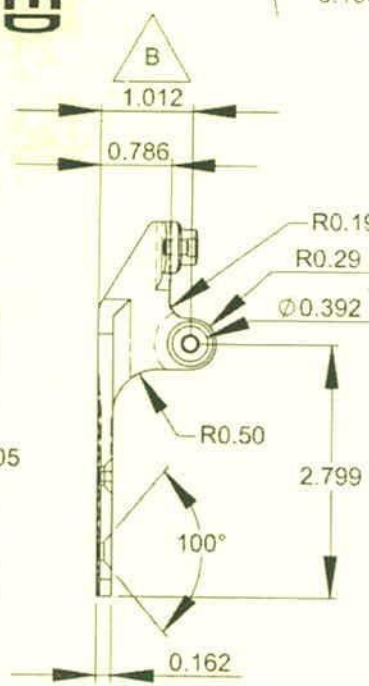


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CHECKED	APPROVED	HAWKESBURY, ONTARIO, CANADA
DATE	DRAWING NO.	REV. C
04.02.17	D3183	SHEET 2 OF 4
TITLE	BRACKET ASSEMBLY	SCALE
		1:2

RELEASED



DEO ATTACHED



D3183-1 BRACKET SHOWN  
D3183-2 BRACKET OPPOSITE

- 1) D3183-1 CAN BE MADE FROM D3183-3  
D3183-2 CAN BE MADE FROM D3183-4
- 2) MATERIAL: 17-4 SS PER AMS 5604/5643  
(REF DART SPEC. M17-4-B)  
MIN ULTIMATE STRENGTH = 150 ksi  
MIN YIELD STRENGTH = 100 ksi
- 3) BREAK ALL SHARP EDGES 0.005 TO 0.015
- 4) ENGRAVE DART P/N & LOGO AS SHOWN
- 5) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 6) ALL DIMENSIONS ARE IN INCHES

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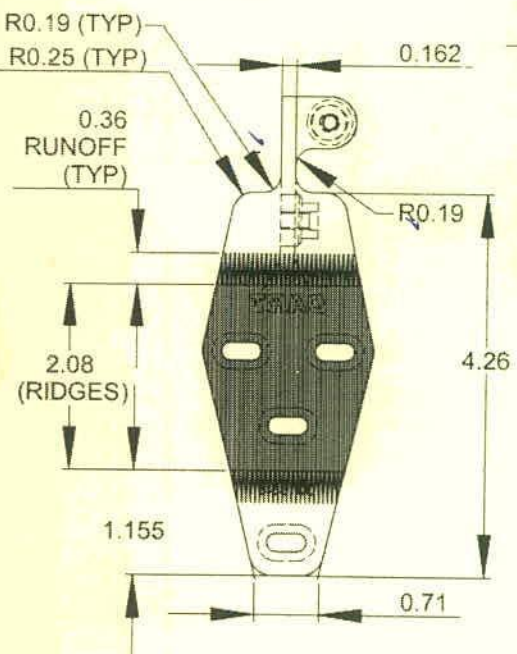
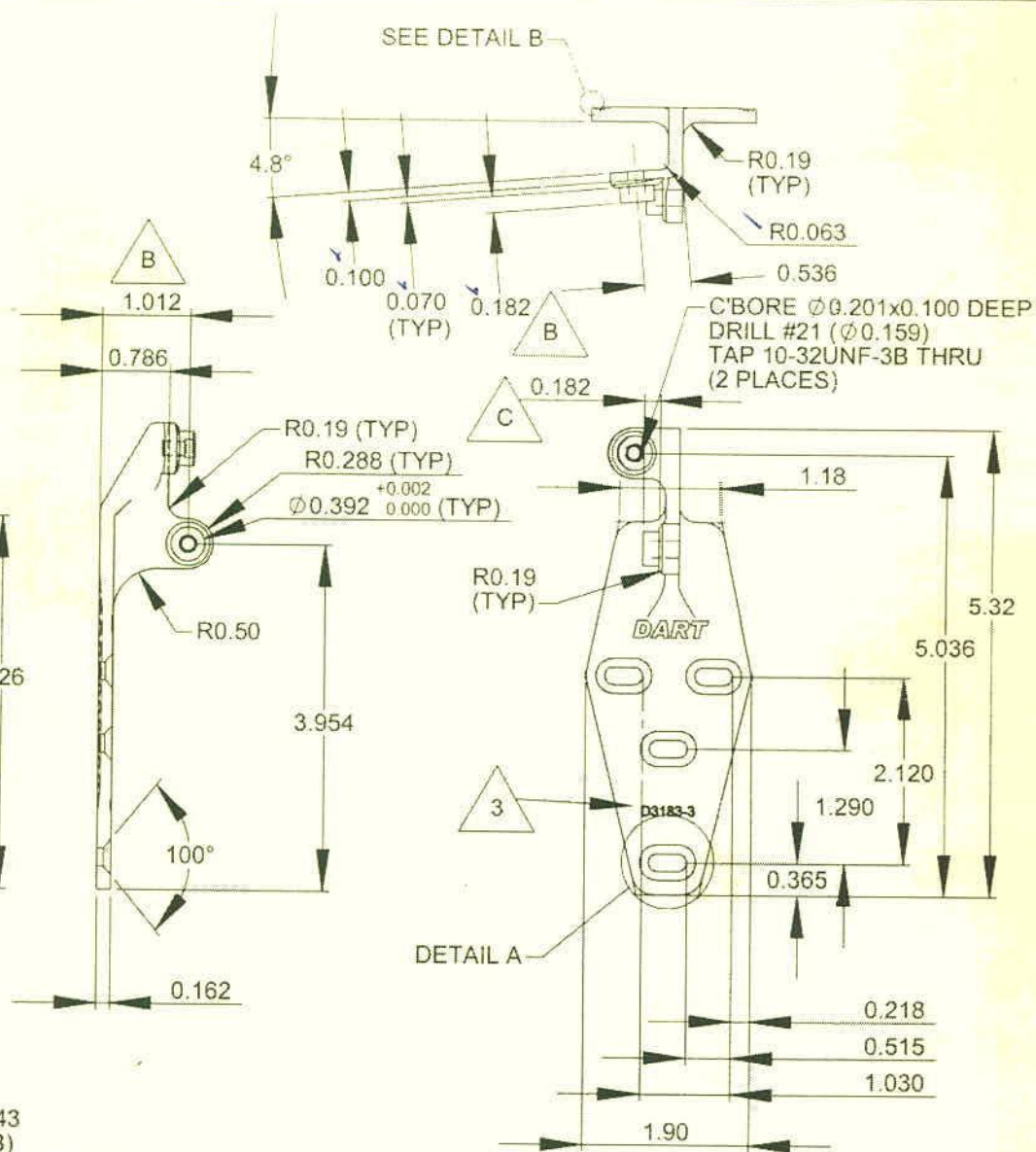


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CHECKED	APPROVED	HAWKESBURY, ONTARIO, CANADA
DATE	DRAWING NO.	REV. C
04.02.17	D3183	SHEET 3 OF 4
TITLE	BRACKET ASSEMBLY	SCALE
		1/2



**D3183-3 BRACKET SHOWN**  
(REPLACES BELL P/N 412-030-304-105)  
**D3183-4 BRACKET OPPOSITE**  
(REPLACES BELL P/N 412-030-304-106)

- 1) MATERIAL: 17-4 SS PER AMS 5604/5643  
(REF DART SPEC. M17-4-B)  
MIN ULTIMATE STRENGTH = 150 ksi  
MIN YIELD STRENGTH = 100 ksi
- 2) BREAK ALL SHARP EDGES 0.005 TO 0.015
- 3) ENGRAVE DART P/N & LOGO AS SHOWN
- 4) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 5) ALL DIMENSIONS ARE IN INCHES

**DEO ATTACHED**

**RELEASED**

24 05 07 #1

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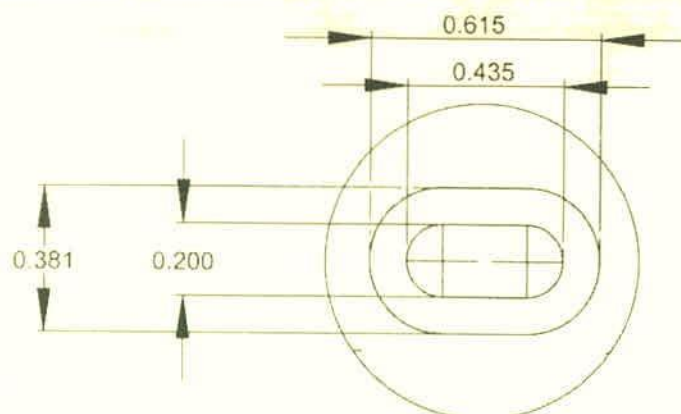
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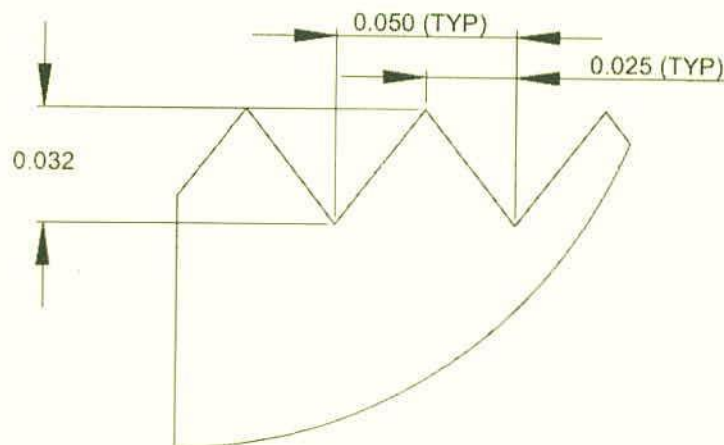
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CHECKED <i>[Signature]</i>	APPROVED <i>[Signature]</i>	DRAWING NO. <b>D3183</b>	REV. C SHEET 4 OF 4
DATE <b>04.02.17</b>		TITLE <b>BRACKET ASSEMBLY</b>	SCALE 1:1



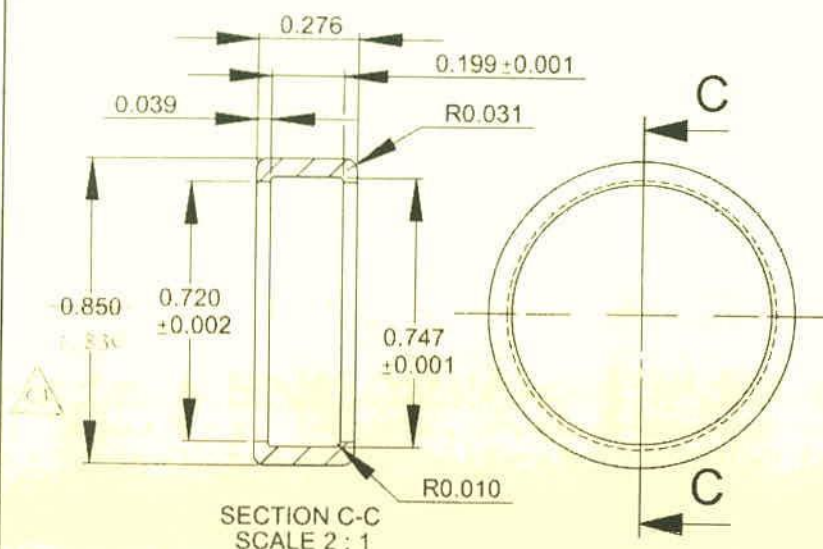
DETAIL A (2 : 1)

RELEASED  
04 03 2017

DEO ATTACHED



DETAIL B (20 : 1)



SECTION C-C  
SCALE 2 : 1

**D3183-9 CAP**

- 1) MATERIAL: DELRIN ROD, Ø1.00  
(REF DART SPEC. M-DELRIN-R1.00)
- 2) TOLERANCES ARE PER DART QSI 018  
UNLESS OTHERWISE NOTED
- 3) ALL DIMENSIONS ARE IN INCHES

**D3183-045 BEARING ASSEMBLY**

- 1) ASSEMBLE D3183-5 BEARING AND  
D3183-9 CAP

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85996



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Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries